



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-540-013
Job Sheet 185664



Part No: D206-540-013

Job Qty: 1 ea

Part Name: 206A/B Heli-Utility-Basket™ - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV K IPP Rev: I Revised as per Rev I 05-12-07 JLM IPP Rev: J reformat 06.04.04 EC IPP Rev: K 07-03-20 As per DSI9361 JLM IPP Rev: L 10.09.29 fixe route seq DD ver: EC IPP REV: M 13.06.26 as per IIN-D206-540 rev. K DD VER: JFS

Ship Via:

6421

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Small Fab-4		11/11/12
110	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00			11/11/12
111	Small Fab	1 pcs	11/30/18	11/30/18	0.00	1.86	Small Fab-1		11/11/12
112	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC5		NOV 13 2018
113	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging 1-3		NOV 15 2018
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC4		NOV 15 2018
125	DC	1 pcs	11/30/18	11/30/18	0.00	0.00	DC		NOV 15 2018
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		NOV 15 2018
140	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21		NOV 15 2018

Part Op 111 - Assemble as per Dwg D206-540

Descriptions: 125 - Photocopy bluefile & type labels per PPP D206-540-013 CHG 006

130 - Identify and pack for shipping as per PPP D206-540-013 Location: FG PPP rev: J

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5089276
AN320-4	Nut	3 Ea (3 ea)	90-Start up Operation	F110349
AN380-2-2	Cotter Pins	3 Ea (3 ea)	90-Start up Operation	F16895
AN4-12	Bolt	2 Ea (2 ea)	90-Start up Operation	5079111
AN4-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5084308
AN4-20A	Bolt	3 Ea (3 ea)	90-Start up Operation	5094470
AN4-21A	Bolt	2 Ea (2 ea)	90-Start up Operation	5089315
AN4-22A	Bolt	2 Ea (2 ea)	90-Start up Operation	F13437
AN4-5A	Bolt	8 Ea (8 ea)	90-Start up Operation	5068646
AN4-8	Bolts	1 Ea (1 ea)	90-Start up Operation	5016395-1
AN5-17A	Bolt	2 Ea (2 ea)	90-Start up Operation	507965
AN970-4	Washer	4 Ea (4 ea)	90-Start up Operation	5126031
D2012-107	Clevis	1 Ea (1 ea)	90-Start up Operation	5086353
D2022-101	Spacer	4 Ea (4 ea)	90-Start up Operation	
D2249-041	Fitting Assembly	2 Ea (2 ea)	90-Start up Operation	
D2258-170	Placard - 170 lb	1 Ea (1 ea)	90-Start up Operation	
D2259	Label	1 pcs (1 ea)	90-Start up Operation	

DQA: _____ Date: _____

mmf
11 Jul 2019

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>D206-540-013</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other																																																																											
Part No. <u>185664</u>		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Thermoforming ☒ Large Fab ☐		Cross tube Small Fab ☐ Finishing Composite ☐		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier ☐																																																																											
NCR No. <u>19-7301</u>		Suspected Unapproved		QTY Effective: <u>1</u>		Disposition		MRB (QSI042) Approval <u>1100 11/16/19</u>																																																																											
Date: _____		Step #: _____		Description Work Order Deviation		Disposition		Completed By <u>11/16/19</u>																																																																											
Buy calls for qty(4) D2931 Bumpers. 122931 Dist has hydraulically installed qty(2)		Acceptable to install qty(2) D2931 Bumpers & associated hardware.		Root Cause <table border="1"><tr><td>Environment</td><td>No Re-verification</td><td>Pressure/Forced</td><td>Temperature/Cure</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Design</td><td>Operator</td><td>Bending</td><td>Set-up</td><td>Folio/Program</td><td>Outside Dimensions</td></tr><tr><td>Doc/Data</td><td>Offset/Setup</td><td>Centre Not Concentric</td><td>BOM/Route</td><td>Broken/Damage/Defect</td><td>Over/Under tolerance</td></tr><tr><td>Equip/Tooling</td><td>Supplier</td><td>Cracks</td><td>Inspection Incomplete/Unqualified</td><td>Weld</td><td>Part Incorrect</td></tr><tr><td>Handling/Pre</td><td>Training</td><td>Crimp/Kink/Ripple/Wave</td><td>Contamination</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Material</td><td>Use for Testing</td><td>Cuffs</td><td>Crushing</td><td>Counter-sink</td><td>Part Moved</td></tr><tr><td>Internal Transport</td><td>Poor Information</td><td>Heat Treat</td><td>Crushing</td><td>Off-set</td><td>Drawing</td></tr><tr><td>Tribal Knowledge</td><td>Rushing</td><td>Wave/Twist in Tube</td><td>Heat Treat</td><td>Mislabeled</td><td>Finish</td></tr><tr><td>LOA</td><td>Product Improvement</td><td>Marks/Chatter</td><td>Wave/Twist in Tube</td><td>Fit/Function</td><td>Mistread</td></tr><tr><td>Substation</td><td>Process Improvement</td><td></td><td>Drill Holes</td><td>Misaligned/off center</td><td>Turning Sequence</td></tr><tr><td>Past Expiry Date</td><td>Manufacturing Process</td><td colspan="4">OTHER: _____</td><td></td></tr><tr><td>Misidentified</td><td>Past Due</td><td colspan="4"></td><td></td></tr></table>						Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions	Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Broken/Damage/Defect	Over/Under tolerance	Equip/Tooling	Supplier	Cracks	Inspection Incomplete/Unqualified	Weld	Part Incorrect	Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Contamination	Wrong Stock Pulled	Part Lost/Missing	Material	Use for Testing	Cuffs	Crushing	Counter-sink	Part Moved	Internal Transport	Poor Information	Heat Treat	Crushing	Off-set	Drawing	Tribal Knowledge	Rushing	Wave/Twist in Tube	Heat Treat	Mislabeled	Finish	LOA	Product Improvement	Marks/Chatter	Wave/Twist in Tube	Fit/Function	Mistread	Substation	Process Improvement		Drill Holes	Misaligned/off center	Turning Sequence	Past Expiry Date	Manufacturing Process	OTHER: _____					Misidentified	Past Due					
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Past Expiry Date	Manufacturing Process	OTHER: _____																																																																																	
Misidentified	Past Due																																																																																		
FAULT CATEGORY																																																																																			

D2330-041	Basket Base Assembly	1 Ea (1 ea)	90-Start up Operation
D2330-043	Basket Lid Assembly	1 Ea (1 ea)	90-Start up Operation
D2332-041	Lid Prop Assembly 6.69"	1 Ea (1 ea)	90-Start up Operation
D2525	Spacer	2 Ea (2 ea)	90-Start up Operation
D2526	Bushing	2 Ea (2 ea)	90-Start up Operation
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation
D2535	Spring	2 Ea (2 ea)	90-Start up Operation
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation
D2748	Clevis	2 Ea (2 ea)	90-Start up Operation
D2749-1	Fwd Strut 206B Basket 9.45"	1 Ea (1 ea)	90-Start up Operation
D2749-7	Strut	1 Ea (1 ea)	90-Start up Operation
D2814	Strut	2 Ea (2 ea)	90-Start up Operation
D2852	Label	2 Ea (2 ea)	90-Start up Operation
D2931	Bumper	4 Ea (4 ea)	90-Start up Operation
D3398-3	Bushings	4 Ea (4 ea)	90-Start up Operation
D3723-1	Bushing	6 Ea (6 ea)	90-Start up Operation
MS20600-AD4W3	Cherry Rivet	4 Ea (4 ea)	90-Start up Operation
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation
MS21042L4	Nut	4 Ea (4 ea)	90-Start up Operation
MS21042L5	Nut	2 Ea (2 ea)	90-Start up Operation
MS27039-4-11	Screw	1 Ea (1 ea)	90-Start up Operation
NAS1149D0463J	Washer	19 Ea (19 ea)	90-Start up Operation
NAS1149D0563J	Washer	2 Ea (2 ea)	90-Start up Operation
NAS1149DN832J	Washer	4 Ea (4 ea)	90-Start up Operation
NAS43DD4-46	Spacer	3 Ea (3 ea)	90-Start up Operation

9126200
 5126225
 5093300
 5115080
 5073832
 5115052
 5076135
 5052209
 5076007
 5094592
 5068662
 5034411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-16A	2	84	0
	AN320-4	3	32	0
	AN380-2-2	3	0	0
	AN4-12	2	173	0
	AN4-12A	2	183	0
	AN4-20A	3	251	0
	AN4-21A	2	80	0
	AN4-22A	2	189	0
	AN4-5A	8	186	0
	AN4-6	1	310	0
	AN5-17A	2	101	0
	AN970-4	4	142	0
	D2012-107	1	30	0
	D2022-101	4	7	0
	D2249-041	2	0	0
	D2258-170	1	12	0
	D2259	1	48	0
	D2330-041	1	0	0
	D2330-043	1	0	0
	D2332-041	1	6	0
	D2525	2	2	0
	D2526	2	17	0
	D2530	1	13	0
	D2535	2	58	0
	D2537	2	40	0
	D2748	2	11	0
	D2749-1	1	0	0
	D2749-7	1	1	0
	D2814	2	1	0
	D2852	2	1	0
	D2931	4	928	0
	D3398-3	4	36	0
	D3723-1	6	9	0
	MS20600-AD4W3	4	319	0
	MS21042L3	2	2,363	0
	MS21042L4	4	3,439	0
	MS21042L5	2	531	0
	MS27039-4-11	1	101	0
	NAS1149D0463J	19	4,347	0
	NAS1149D0563J	2	1,012	0

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 Hamilton, ON K8A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S127447

Part: D206-540-013

Job No: 185664

Serial No/Batch: S127447

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH94 - 5 Issue 405A/STG SR00386NY 00/02/15, LBA GERH

DOI:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

OA closed:

Date:

QA Closed:		Date:		Work Order update only	
Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
NCR No. _____		QTY Effective :		MRB (QS1042) Approval	
Date : _____		Step #:		Disposition	
Description Work Order Deviation		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

NAS1149DN832J
NAS43DD4-46

4
3

942
24

0
0

Part Specifications

Specifications could not be found.

Plex 10/31/18 9:53 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other	
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier	
NCR No. _____		Suspected Unapproved		QTY Effective: _____				MRB (QSI042) Approval	
Date: _____	Step #: _____			Disposition				Completed By	
Description Work Order Deviation									
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY											
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong					
Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions					
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance					
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect					
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing					
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved					
Internal Transport		Poor Information		Crushing		Countersink		Off-set		Drawing					
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish					
LOA		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread					
Substation		Process Improvement		Marks/Chatter				Misaligned/off center		Turning Sequence					
Past Expiry Date		Manufacturing Process													
Misidentified		Past Due													

OTHER: _____

Change Record

PAGE 1 OF 1

Part Number: D206-540-013

Description: HELI-UTILITY BASKET (206A/B)

[illegible]

